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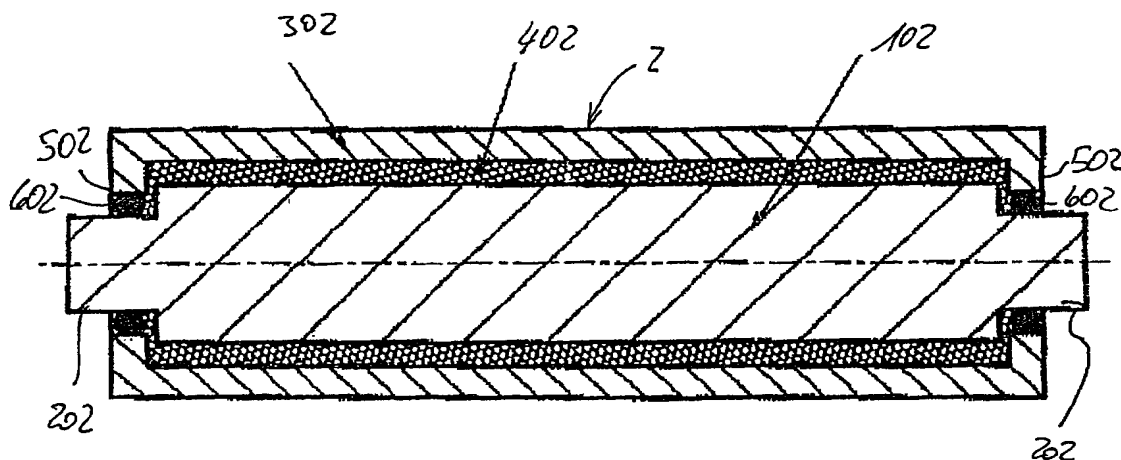
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- (71) Applicant (for all designated States except US): **AGNATI S.P.A.** [IT/IT]; Via Lecco, 72, I-20059 Vimercate (IT).
- (72) Inventors; and
- (73) Inventors/Applicants (for US only): **ROSSI, Giuliano** [IT/IT]; Viale C.M. Maggi, 27, I-20050 Lesmo (IT). **SCENINI, Giancarlo** [IT/IT]; Via S. Donato 29, I-20052 Monza (IT). **GIOVE, Raffaele** [IT/IT]; Viale A. Mantegna 109, I-20043 Arcore (IT).
- (74) Agent: **KARAGHIOSOFF, Giorgio, A.**; Studio Karaghiosoff & Frizzi S.a.s., Via Pecorile, 27/B, I-17015 Celle Ligure (IT).
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(54) Title: DAMPING CORRUGATOR ROLL



(57) Abstract: A damping corrugator roll comprises an outer toothed surface, whose teeth extend over a certain axial length of the roll (2), support means (202) allowing rotation about the axis of the roll, and rotary drive means (1), characterized in that it comprises a cylindrical core which is supported for free rotation at its ends, and whereon a toothed peripheral cylindrical jacket is supported by and interposed or bearing material.

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Damping corrugator roll

The invention relates to a damping corrugator
5 roll, comprising an outer toothed surface, whose teeth
extend over a certain axial length of the roll, support
means allowing rotation about the axis of the roll, and
rotary drive means.

The invention particularly relates to a corrugator
10 roll of the above type, provided in combination with an
upper corrugator roll, parallel and tangent to said
lower roll, both rolls being part of a corrugator unit
for paper sheets, in corrugated board fabrication.

As a rule, the upper corrugator roll has a greater
15 diameter and is rotatably driven, but it also has
peripheral skirt teeth, whereby it meshes with the
teeth of the lower corrugator roll, which runs idle and
is rotatably dragged along by the upper corrugator
roll.

20 In prior art machines, a severe problem is the
very high level of noise generated by the corrugator
unit. This noise is caused by the generation of
vibrations and oscillations, mainly in the lower
corrugator roll, which, according to current
25 manufacturing trends, is smaller than the upper
corrugator roll, hence more exposed to the excitation
of vibrations.

There may be different kinds of vibrations, i.e.
they may depend on flexures transverse to the axis of
30 rotation, or on torsional flexures, i.e. in the

circumferential direction with respect to the axis of the roll. Vibrations also depend of the shape of the corrugator teeth of the two rolls which, in combination with the paper feed, cause the vibratory motion of the roll. Due to the considerable axial lengths of rolls, the vibratory and/or oscillatory effects are particularly felt in the center part of the roll, i.e. far from the support constraints at the ends thereof. Also, in this center part, the vibratory and/or oscillatory effects are relatively out of control and dependent on the features of the processed paper.

Prior art damping means can absorb or damp at least part of the vibrations at the end constraints of the lower corrugator roll, but definitely cannot handle neither systematic nor casual oscillations or vibrations (the latter due to modified features of the paper being processed) at the center part of the corrugator roll. Therefore, a relatively poor damping effect is always obtained, whereby to date a still high level of noise is generated by corrugator units, such that it requires expensive and complex acoustical treatments on machines.

Moreover, vibrations and/or oscillations cause functional problems, such as the need to limit the production rate because the poor vibration dampening causes a loss of attachment between the layers of the corrugated board and a smaller flute width.

The invention has the object to provide a damped, particularly lower corrugator roll, so that, by simple and relatively inexpensive arrangements, the drawbacks

of prior art rolls can be obviated, by effectively damping the generation of vibrations and/or oscillations, hence by drastically reducing the noise effect and the functional drawbacks due to poor
5 damping.

The invention achieves the above objects by providing a corrugator roll as described hereinbefore, comprising:

A cylindrical core which is supported for free
10 rotation at its ends and whereon a toothed peripheral cylindrical jacket is supported in a floatable manner by an interposed or bearing material.

The bearing or interposed material may consist of a fluid, such as a gas, a liquid, a highly viscous
15 liquid or, for instance, having a pasty consistency, or of a solid material having a highly hysteretic elastic behavior.

The characteristics of the gaseous, liquid or pasty fluid shall be such that the friction coefficient
20 of said materials with respect to the surfaces in contact therewith, that is the outer skirt of the core and the inner skirt of the floating jacket, will increase as the relative speed between the floating jacket and the cylindrical core increases.

25 The interposed or bearing fluids may be provided under pressure, at atmospheric pressure, or in conditions of negative pressure with respect to external atmospheric pressure. This depends on the conditions of use.

30 It may be also provided that the jacket and the

cylindrical core form, e.g. by using rotary sealing heads, a sealed hollow space wherein the interposed material is introduced and replaced from time to time after a predetermined number of operating hours.

5 Alternatively, the sealed hollow space formed by the tubular cylindrical jacket and by the cylindrical core may have inlets and outlets for automatic feeding of or filling up with the interposed material, in this case fluid, or for generating a continuous or batch
10 circulation of said fluid, which can provide balanced dynamic conditions in the hollow space as regards pressure and quantity of fluid. At the same time, the circulation of fluid ensures a constant renewal thereof, for instance with respect to the maintenance
15 of a predetermined temperature or of a predetermined mixture composition or condition, or of any other parameter that can be affected by the use and restored by service treatments.

 Advantageously, the sealing means at the heads of
20 the tubular toothed cylindrical jacket are such that they allow, by using yielding members, the jacket to be moved at least transverse to the core.

 The cylindrical jacket has lower weight and inertia values as compared with the central core.

25 Depending on the length, the length to diameter ratio of the lower roll, i.e. of the jacket of the lower roll is higher than 10. The jacket shall be relatively thin, but anyway have a sufficient thickness to allow paper processing.

30 As a rule, the diameter to thickness ratio is of 8/1 to

15/1, preferably of about 10/1.

For diameters and lengths commonly used in corrugator machines, the thickness of the jacket may range from 10 to 100 mm, particularly from 20 to 50 mm, preferably from 25 to 35 mm.

The hollow space or chamber, or the difference between the outside diameter of the core and the inside diameter of the jacket is of 0,1 to 5 mm, also depending on the diameter and length of the jacket as well as on the type of interposed material.

The outer jacket can be made of any suitable material, also composite or in two, three or more layers.

For instance, the material to be used can be steel or other metals, preferably after undergoing hardening treatments, such as quenching or coating with hard layers, e.g. made of tungsten carbide, hard chromium or titanium nitrides.

The invention is based on the acknowledgement that, during operation, the vibrations in the floating jacket cause variations in the bearing thickness (thickness of the hollow space between the floating jacket and the cylindrical core), hence in the bearing fluid. Bearing thickness deformations cause variations in the relative speed of the filling or bearing material, hence variations in the friction coefficient, which have the effect of damping the motions and stresses that generate vibratory motions.

The arrangement according to the invention leads to unexpected advantages in combination with bthe

toothed corrugator rolls . An effectively damping lower corrugator roll is the most appetizing and required thing in the field. A drastic reduction of the noise generated by vibrations would allow to reduce economic and construction efforts for acoustical treatments. Yet, the floating suspension of the lower corrugator roll does not require to account for the specificity of shapes or profiles of the corrugator teeth, since such floating suspension allows a wide adaptability to the teeth shapes, as regards both noise generation and functional effectiveness of the corrugator unit. More particularly it has to be noted that the teeth of corrugator rolls cooperating with each other are not designed to lead to a homocinetic kind of motion. This means that the way two corrugator rolls cooperate with each other is not similar to the way as two gears cooperate with each other, since the teeth are designed in order to corrugate sheets of paper without damaging the paper. The corrugator rolls are affected not only by vibration modes due their own motion but also by vibrations which are induced by the teeth and the paper being treated. The bearing fluid or material interposed between the core of the roll and the toothed jacket has shown a high speed of reacting to the induced vibrations thus leading to an effective damping of the vibrations which was unexpected in the technical field on the light of the actual knowledge.

Further unexpected advantages consist in the fact that the bearing fluid or material leads to a uniform distribution of the pressure exerted by the corrugator

roll over its entire length. This effect allows to avoid particular shaping of the corrugator roll with respect to a cylindrical form. Furthermore, the supports at the ends of the corrugator roll are less stressed than in the case of the known corrugator rolls. Thanks to the above advantages also the frequency of regeneration of the corrugator rolls is reduced, lowering costs for the manufacturers and obviating to have a production line stopped for longer time. It has to be noted that corrugator rolls are very large and big so that it is not quite simple to send the rolls back to the manufacturer for regeneration. Also the regeneration treatment is expensive and time consuming.

A particular advantage appears applying the construction of the corrugator roll according to the present invention in combination with a corrugator unit, particularly for sheets or webs of paper, or similar, of the type comprising at least two rolls having a toothed or corrugated surface and being mutually engaged and pushed against each other by a predetermined pressure or force, the mutual compression between rolls being exerted over the whole axial length of the rolls through mechanical or magnetic means as described in EP 98112227.8.

In this case a cradle made of a series of several wheels or belts. Particular advantages results in a corrugator unit of the above mentioned kind in which one of the at least two corrugator rolls has a smaller diameter than the other roll.

The damping effectiveness obtained by the roll according to the invention also allows to improve the functionality of the corrugator unit, e.g. with reference to the possibility of increasing the
5 corrugated board production rate, without incurring in manufacturing defects, such as gluing defects and/or variations in flute width.

The invention also relates to further improvements, which form the subject of the dependent
10 claims.

The characteristics of the invention and the advantages derived therefrom will appear more clearly from the following description of a non-limiting embodiment, illustrated in the annexed drawings, in
15 which:

Figs. 1 and 2 are a schematic axial sectional view and a schematic transverse sectional view respectively of a roll according to the invention.

Fig. 3 is an axial sectional view of an embodiment
20 of a roll according to the invention.

Fig. 4 is an axial sectional view of the outer toothed cylindrical jacket.

Fig. 5 is an axial sectional view of the sealing heads of the cylindrical jacket.

25 fig. 6 is a view of the cylindrical core.

Fig. 7 shows a general corrugator unit with a pair of toothed rolls, an upper and a lower roll.

Referring to figs. 1, 2 and 7, a corrugator unit comprises a pair of peripherally toothed meshed
30 corrugator rolls 1 and 2. One corrugator roll, the

upper one 1, has a relatively great diameter and is rotatably supported and driven at its ends. The second corrugator roll, the lower one 2, has a considerably smaller diameter and is supported in a pressure cradle, composed of belts, pairs of rollers, or else. The lower corrugator roll 2 is pushed with a predetermined force against the upper corrugator roll 1.

Figs. 1 and 2 are very schematic views of the construction principle of the lower corrugator roll according to the present invention. This roll consists of a cylindrical core 102, which has rotary support extensions 202 at its ends, whereby the cylindrical core 102 is mounted for free rotation onto the support frame, for instance of the corrugator unit. The cylindrical core 102 is held inside a cylindrical jacket 302, whose inside diameter is greater than the outside diameter of the cylindrical core, thereby forming a cylindrical hollow space 402 between said two parts. In principle, the hollow space cannot be closed at the end sides. Further, if the jacket 302 has partial or complete heads 502 through which the extensions 202 for support of the cylindrical core 102 extend, then these heads shall be elastically coupled to the core supporting extensions 202, i.e. so that the tubular cylindrical jacket 402 can move transverse to the cylindrical core, at least within the limits of the order of magnitude of the vibrations to be damped. This is shown by the elements denoted with numeral 602.

The hollow space 402 can simply contain air at atmospheric pressure, or at different over- or

underpressures, or mixtures of gases, liquid fluids or mixtures of liquid fluids, having different, preferably high viscosity values, or highly viscous, or pasty materials, such as fat, or the like.

5 Liquid fluids may include water, oil, mixtures of water and oil, plastic polymers in liquid form, and any type of liquid having the physical characteristics fit for the purpose.

 Alternatively, the space 402 can be filled with a
10 solid plastic material of the elastic type, particularly having a highly hysteretic elasticity.

 The fluid materials held in the hollow space 402 preferably have such characteristics as to generate friction coupling between the jacket 302 and the core
15 102, the friction coefficient being such that it increases as the rotation speed difference between the core and the jacket increases.

 Then, the tubular jacket 302 rotates freely around the core, substantially floating on an intermediate
20 bearing layer. The jacket is rotatably driven by the upper corrugator roll 1 against which it is pushed, for instance by the belts 8. The core is also rotatably dragged along by the jacket, by being coupled thereto through the fluid or solid bearing substance. The
25 rotation of the core is necessary for the storage of a sufficient inertia, which would not be possessed by the jacket alone. Inertia is required to ensure that the motion conditions of the jacket are as independent as possible from small variables of the product or
30 operating conditions.

The fluid or other mass provides the translation of the jacket vibrations into local variations of width of the hollow space and hence into local variations of speed or local gradients of speed, which locally
5 generate an increase of friction, hence the absorption of the energy caused by vibrations, whereupon the latter are at least partially damped.

The cylindrical core 102 is generally made of solid steel. The jacket may be made of steel or of any
10 other metal, preferably after undergoing surface hardening treatments, such as quenching or coating with layers of a hard material, e.g. tungsten carbide, hard chromium, etc. and/or titanium nitrides.

The thickness of the jacket varies with its
15 diameter, the latter being subject to restrictions based on the length. Generally, with length to diameter ratios higher than 10, the diameter to thickness ratio of the jacket is of 8:1 to 15:1, particularly of 10:1. For usual roll lengths, thickness may range from 10 to
20 100 mm, particularly from 20 to 50, especially from 25 to 35 mm.

The hollow space must not be excessively thick. It can have a thickness of 0.1 to 5 mm.

With reference to figs. 3 to 5, a definitely non-
25 limiting construction embodiment of the invention concept is shown.

The cylindrical core 1, with the extensions 202 thereof, is slipped into a jacket element 302, which has an inner layer 3 made of a highly hysteretic
30 elastic plastic material. Said material is preshaped to

hold the heads 4 for rotatably sealing the jacket, while allowing transverse staggering movements.

Advantageously, the layer 3 at the heads of the jacket 302 may have a recess for housing the sealing heads 4, which are properly positioned and locked therein with the desired sealing effect. These heads have no support function on the jacket 302 but are only used to contain substances, fluids or liquids held in the hollow space.

10 The inner plastic layer 3 can have the function of directly damping vibrations.

In combination with said plastic layer and the core 102, a hollow space may be provided which is filled with air or another fluid, particularly with a viscous liquid.

In this case, the elastic or viscous vibration absorption behavior may be calibrated by combining two or more layers for bearing the jacket 302.

20 The layer 3 may also be made of metal while the hollow space alone may be filled with the bearing fluid.

As shown in the figures, and particularly in figures 3 and 5, the heads 4 may have in this case inlets and/or outlets 104 for the bearing and/or interposed fluid. These can be simply used for occasionally filling and/or topping up the hollow space 402 with the bearing fluid. Alternatively, the fluid may be made to permanently circulate between a storage tank and the hollow space, thereby allowing adjustment of the physical and/or composition parameters of the

fluid, e.g. by adjusting temperature when the roll is in use.

Obviously, the illustrated constructions are not intended to restrict the previously disclosed principle
5 of the invention and can be extended to further types of rolls, both for board production industry and for other sectors, having equal problems.

CLAIMS

1. A damping corrugator roll comprising an outer toothed surface, whose teeth extend over a certain axial length of the roll (2), support means (202) allowing rotation about the axis of the roll, and rotary drive means (1), characterized in that it is composed of a cylindrical core which is supported for free rotation at its ends, and whereon a toothed peripheral cylindrical jacket is supported by an interposed or bearing material.

2. A roll as claimed in claim 1, characterized in that it comprises:

A cylindrical core (102) which is supported for free rotation at its ends (202);

A relatively thin coaxial tubular cylindrical jacket (302), only coupled to the cylindrical core through a solid, fluid, that is gaseous, liquid or pasty material having high viscosity values, i.e. whose friction increases as the speed relative to a body in contact with said material increases, and having an elastic behavior;

the tubular jacket having outer teeth and having no rigid constraint in its radial position with respect to the cylindrical core.

3. A roll as claimed in claim 1 or 2, characterized in that the bearing or interposed material may consist of a fluid, such as a gas, a liquid, a highly viscous liquid, or, for instance in the form of paste, or of a solid material having a highly hysteretic elastic behavior.

4. A roll as claimed in one or more of the preceding claims, characterized in that the characteristics of the gaseous, liquid or pasty fluid shall be such that the friction coefficient of said materials with respect to the surfaces in contact therewith, that is the outer skirt of the core and the inner skirt of the floating jacket, will increase as the relative speed between the floating jacket and the cylindrical core increases.

5. A roll as claimed in one or more of the preceding claims, characterized in that the interposed or bearing fluids may be provided, at atmospheric pressure, under pressure or in conditions of negative pressure with respect to external atmospheric pressure.

6. A roll as claimed in one or more of the preceding claims, characterized in that it may be provided that the jacket (302) and the cylindrical core (102) form, e.g. by using rotary sealing heads (4), a sealed hollow space (402) wherein the interposed material is introduced and may be replaced after a predetermined number of operating hours.

7. A roll as claimed in one or more of the preceding claims, characterized in that, alternatively, the sealed hollow space (402) formed by the tubular cylindrical jacket (202) and by the cylindrical core (302) may have inlets and outlets (105) for automatic feeding of or filling up with the interposed material, in this case fluid, or for generating a continuous or batch circulation of said fluid, which circulation is controlled so that it can generate balanced dynamic

conditions in the hollow space (402) as regards pressure and quantity of fluid.

8. A roll as claimed in one or more of the preceding claims, characterized in that, in combination, it
5 comprises means for circulation of the bearing or interposed fluid and means for constant or batch renewal and/or conditioning of said fluid. e.g. with respect to the maintenance of a predetermined temperature or of a predetermined composition or
10 condition of the fluid components.

9. A roll as claimed in one or more of the preceding claims, characterized in that the means (5) for sealing the heads of the tubular toothed cylindrical jacket (302) are such that they allow, by
15 using yielding members (602), the jacket (302) to be moved at least transverse to the core (102).

10. A roll as claimed in one or more of the preceding claims, characterized in that the cylindrical jacket (302) has lower weight and/or inertia values as
20 compared with the central core (102).

11. A roll as claimed in one or more of the preceding claims, characterized in that depending on the length, the length to diameter ratio of the lower roll (2), i.e. of the jacket (302) of the lower roll
25 (2) is higher than 10. 12. A roll as claimed in one or more of the preceding claims, characterized in that the jacket (302) is relatively thin, but anyway has a sufficient thickness to allow paper processing.

13. A roll as claimed in one or more of the preceding
30 claims, characterized in that the ratio of the diameter

of the roll (2) to the thickness of the jacket (302) is of 8/1 to 15/1, preferably of about 10/1.

14. A roll as claimed in one or more of the preceding claims, characterized in that the hollow space or
5 chamber (402), or the difference between the outside diameter (1) of the core and the inside diameter of the jacket is of 0,1 to 5 mm, also depending on the diameter and length of the jacket as well as on the type of interposed material.

10 15. A roll as claimed in one or more of the preceding claims, characterized in that it can be made of any suitable material, even composite or composed on one, two, three or more layers.

15 16. A roll as claimed in claim 15, characterized in that the material to be used can be steel or other metals, preferably after undergoing hardening treatments, such as quenching or coating with hard layers, e.g. made of tungsten carbide, hard chromium or titanium nitrides.

20 17. A roll as claimed in one or more of the preceding claims, characterized in that the hollow space (402) may be filled with one, two or more layers of interposed or bearing material, which form a combined filling.

25 18. A roll as claimed in one or more of the preceding claims, characterized in that both the jacket (302) and the material for filling the hollow space (402) are double-, triple-, or multilayer.

30 19. A roll as claimed in one or more of the preceding claims, characterized in that it is provided

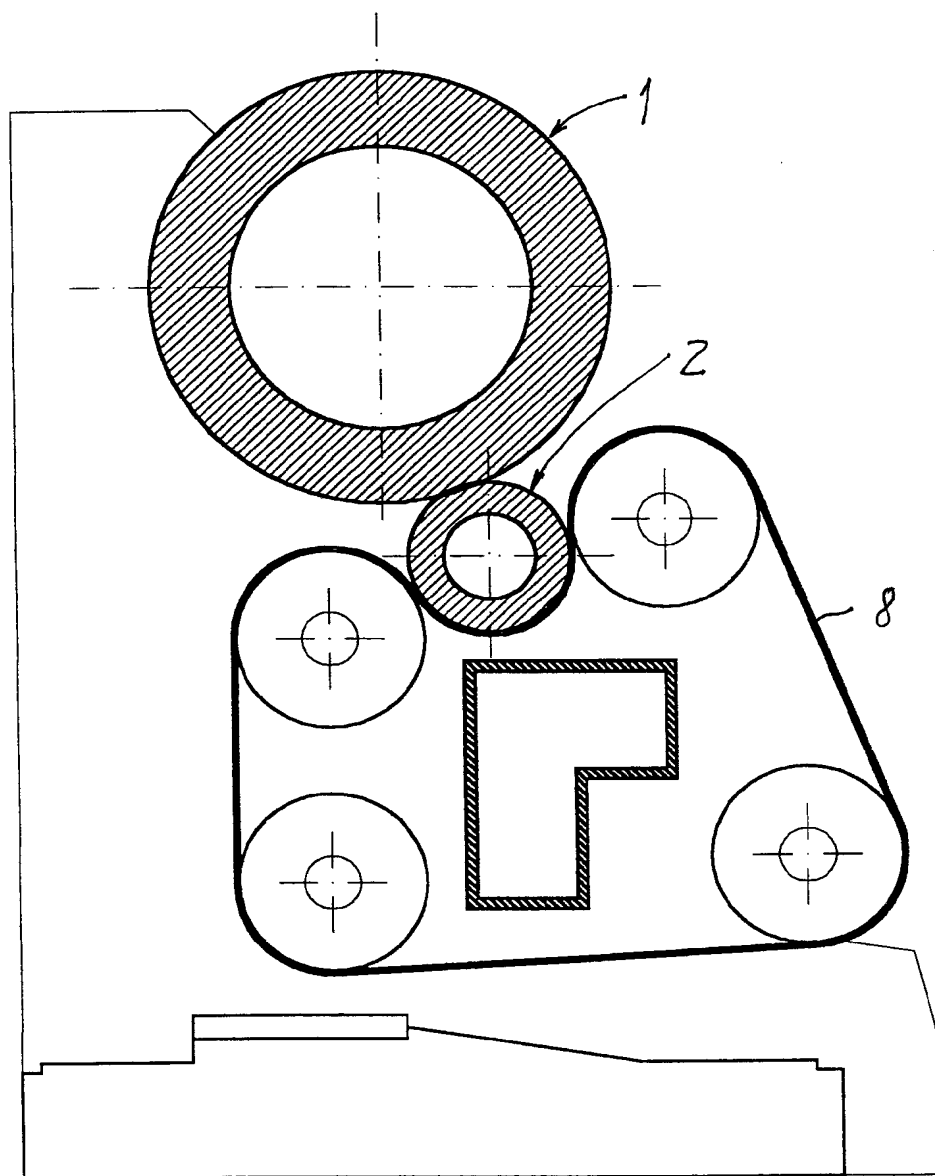
in combination with another corrugator roll (1),
wherein it is tangent, while said other roll (1) meshes
by its peripheral teeth with the peripheral teeth of
the roll (2), said two rolls (1, 2) being part of a
5 corrugator unit for fabricating corrugated board.

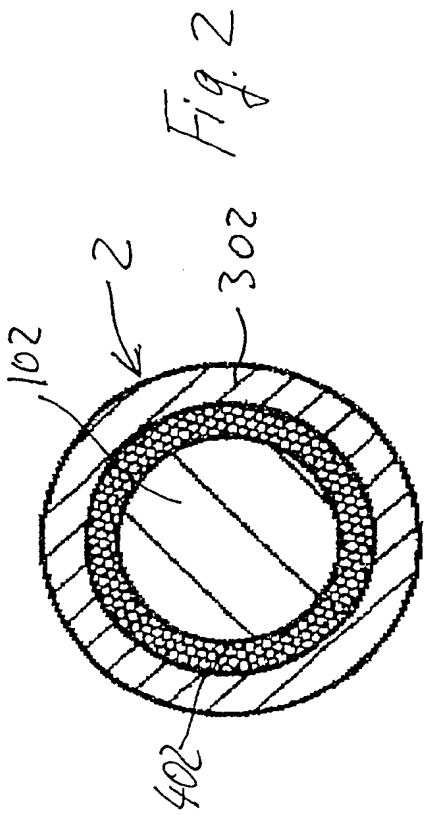
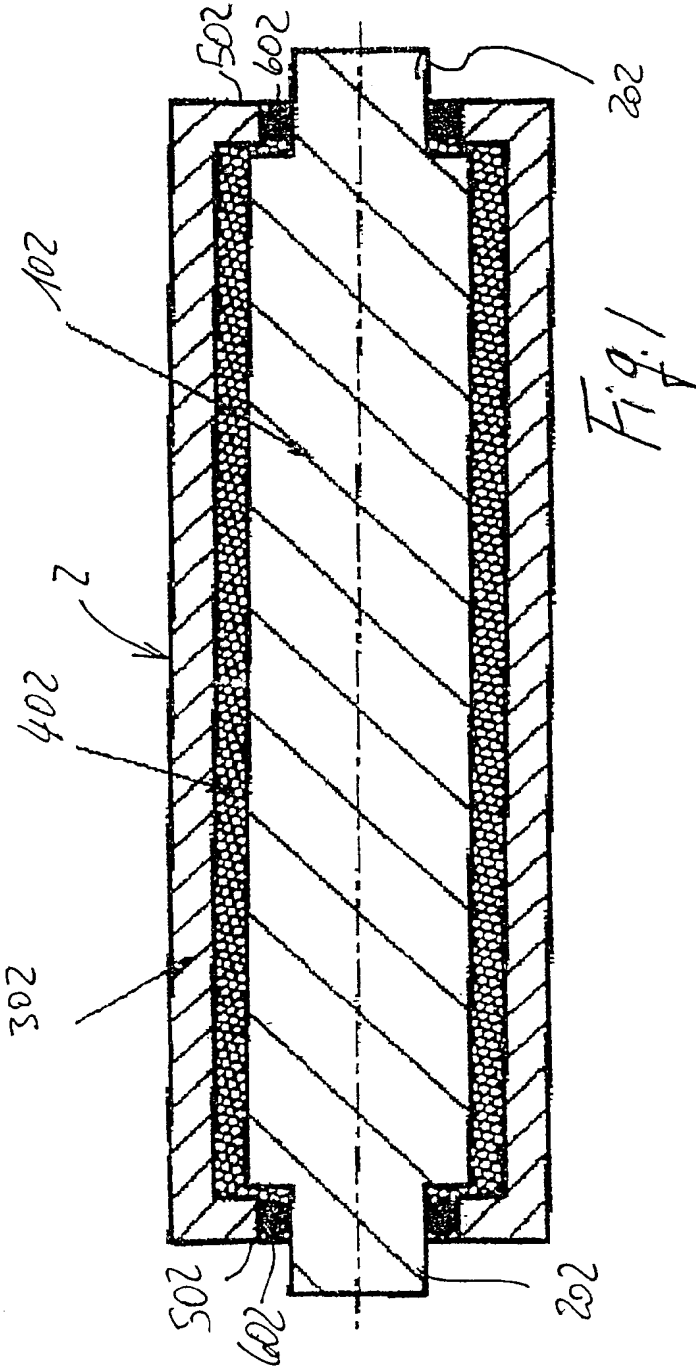
20. A roll as claimed in claim 1 and in one or
more of the succeeding claims 2 to 19, characterized in
that it has no outer toothing and/or it is not part of
the corrugator unit.

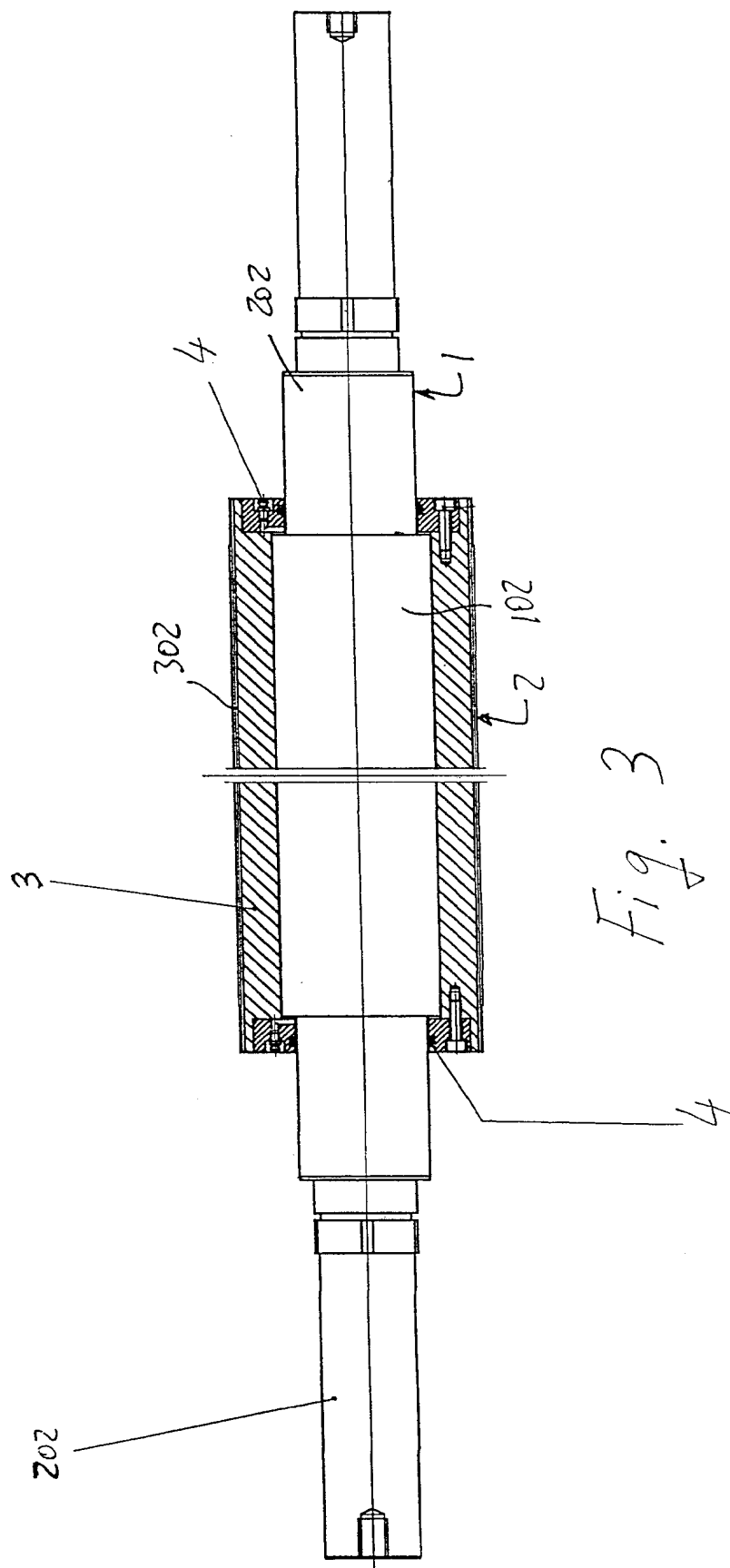
10 21. A damping corrugator roll according to one or
more of the preceding claims, characterized in that it
is provided in combination with a corrugator unit,
particularly for sheets or webs of paper, or similar,
of the type comprising at least two rolls having a
15 toothed or corrugated surface and being mutually
engaged and pushed against each other by a
predetermined pressure or force, the mutual compression
between rolls being exerted over the whole axial length
of the rolls through mechanical or magnetic means and
20 in which one of the corrugated rolls is a corrugator
roll according to one or more of claims 1 to 20.

22. A corrugator roll according to claim 21
characterised in that it is supported by a cradle made
of a series of several wheels or belts, the wheels or
25 the belts being provided in combination with means for
regulating the force exerted on the corrugator roll
against the cooperating corrugator roll.

23 A corrugator roll according to claims 21 or 22,
characterized in that it has a smaller diameter than
30 the other corrugator roll with which it cooperates.

*Fig. 7*





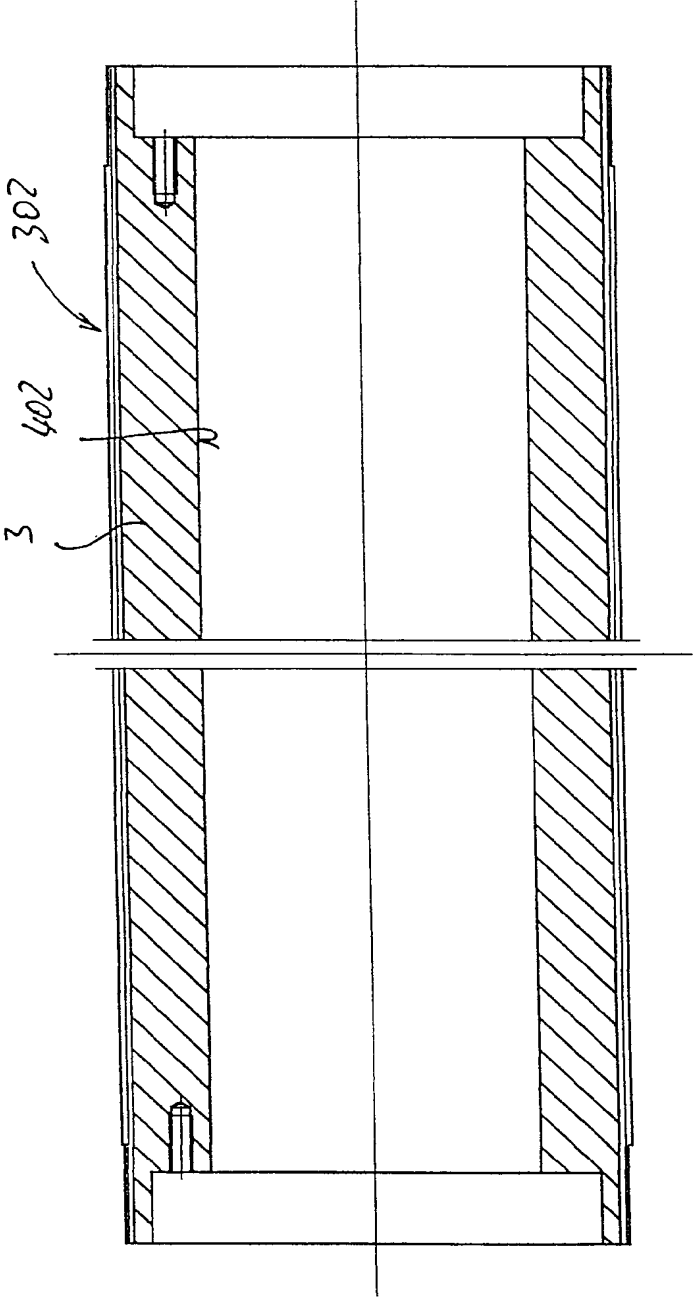


Fig 4

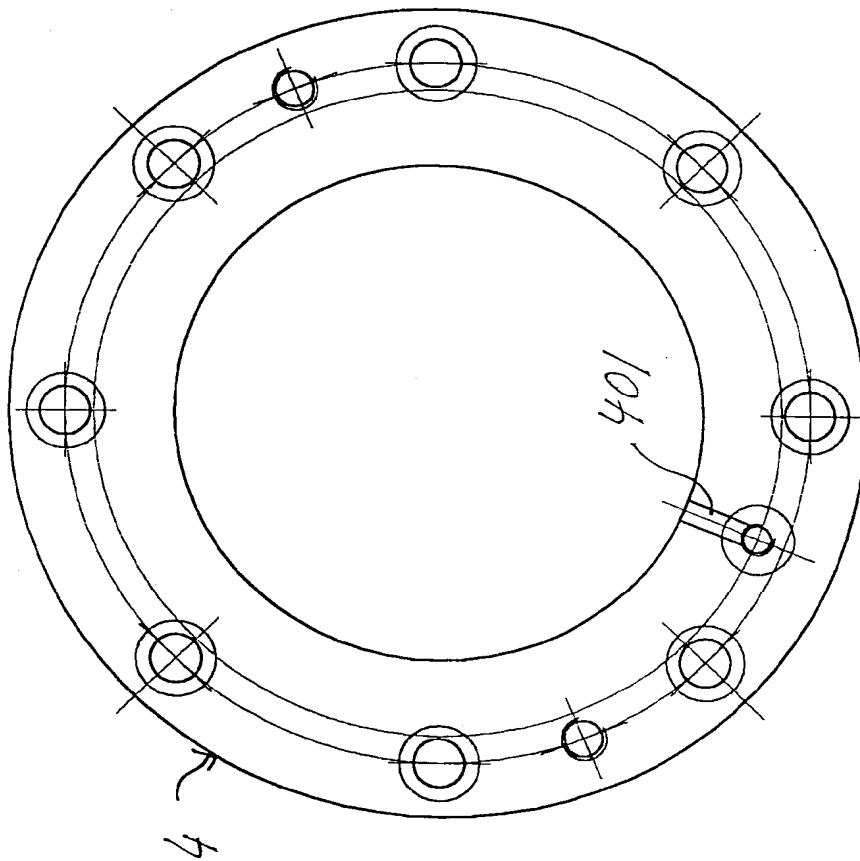
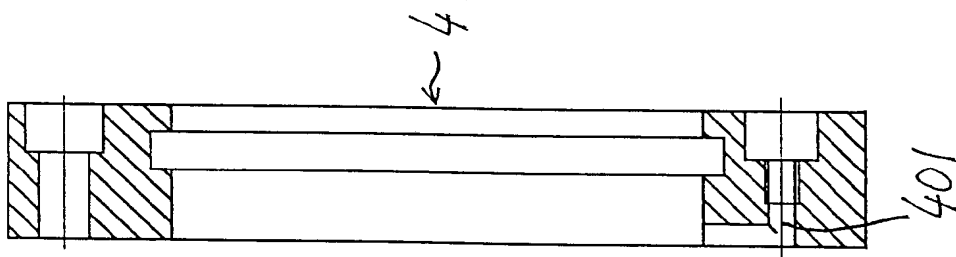


Fig. 5



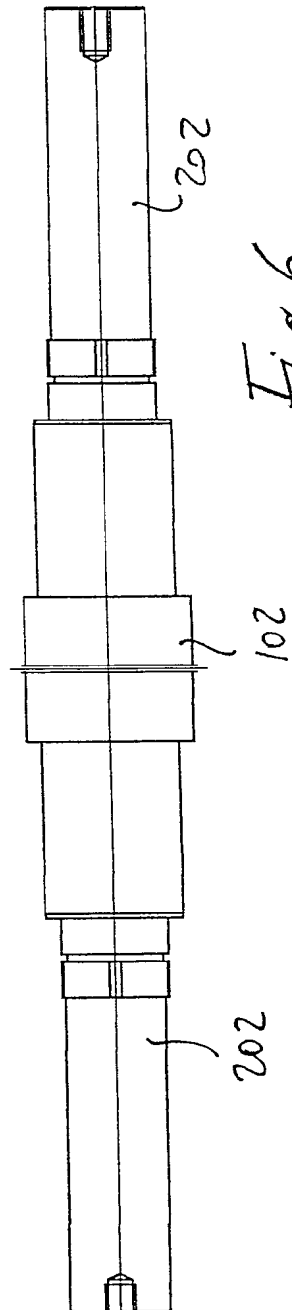
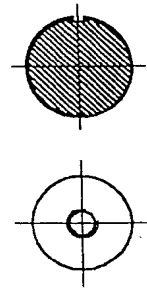


Fig. 6

INTERNATIONAL SEARCH REPORT

International Application No

PCT/EP 00/10795

A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 B31F1/28

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B31F D21G F16C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

WPI Data, PAJ, EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 5 081 759 A (SCHIEL CHRISTIAN) 21 January 1992 (1992-01-21) abstract column 2, line 32 - line 65; claims	20
Y		21-23
A		1-19
X	GB 1 036 922 A (AB KARLSTADS MEKANISKA VERKSTAD) 20 July 1966 (1966-07-20) page 1, left-hand column, line 24 - line 33; claims; figures	20, 21
A		1-19
X	US 5 487 715 A (SCHIEL CHRISTIAN) 30 January 1996 (1996-01-30) abstract column 1, line 34 - line 50	20
A		1-19
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☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

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A document defining the general state of the art which is not considered to be of particular relevance

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X document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

Y document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

S document member of the same patent family

Date of the actual completion of the international search

11 January 2001

Date of mailing of the international search report

19/01/2001

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European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Soederberg, J

INTERNATIONAL SEARCH REPORT

International Application No
PCT/EP 00/10795

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	EP 0 890 429 A (AGNATI SPA) 13 January 1999 (1999-01-13) cited in the application abstract; figure 3	21-23
A	---	19, 20
A	US 4 760 631 A (BRENDL BERNHARD) 2 August 1988 (1988-08-02) -----	

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

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